

# Work Order ID 51094

July 31, 2009 8:38:16 AM



Page 1

Item ID: D3520-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 06/08/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 26/08/2009 Req'd Qty: 20.00



Customer:

Reference:

*08-07-31*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3520

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks 1.400" long

*M.A 09/08/07*

*20*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA646 Rev: *AA* & Dwg D3520 Rev: *A* ☐ 2-Deburr

*8/09/08/10*

*20*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*8/09/08/10*

*20*

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the success of the project.

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

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**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

**Stop**

### Operation Description

### Set Up/ Run Hours

**Draw  
Number**

**Draw**  
**Rev.**

**Plan,  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

130

QC8- Inspect parts - second check

0.00

QC

## Memo

0.00

### Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**HandFinish**

## Memo

0.00

## Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**Powdercoat**

## Memo

0.00

## Powder Coating

START TIME: 11:40pm OVEN TEMPERATURE: 370°F  
FINISH TIME: 12:50am

17:50 ☐ FINISH TIME:

370912

= 44 09 108/11 (X20)

# Work Order ID 51094

July 31, 2009 8:38:16 AM



Page 3

Item ID: D3520-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 06/08/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 26/08/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

=> 801/08/11



QC

Memo

0.00

Quality Control

counts  
120

✓

170

Identify as per dwg & Stock Location: 107

0.00

mo 09/08/11



Packaging

Memo

0.00

Packaging

x20

sf

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

120

h

CY 09/08/12

# Picklist Print

Page 1

July 31, 2009 8:38:15 AM

Work Order ID: 51094

Parent Item: D3520-1RevA

Parent Item Name: Spacer



Comments:

Start Date: 06/08/2009

Required Date: 26/08/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.500X01.00 0		Purchased	No			110	f	29.5900	2.4421			
<div>   </div>												
6061-T6 Bar .500 x 1.00												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

107436

29.59

29.59

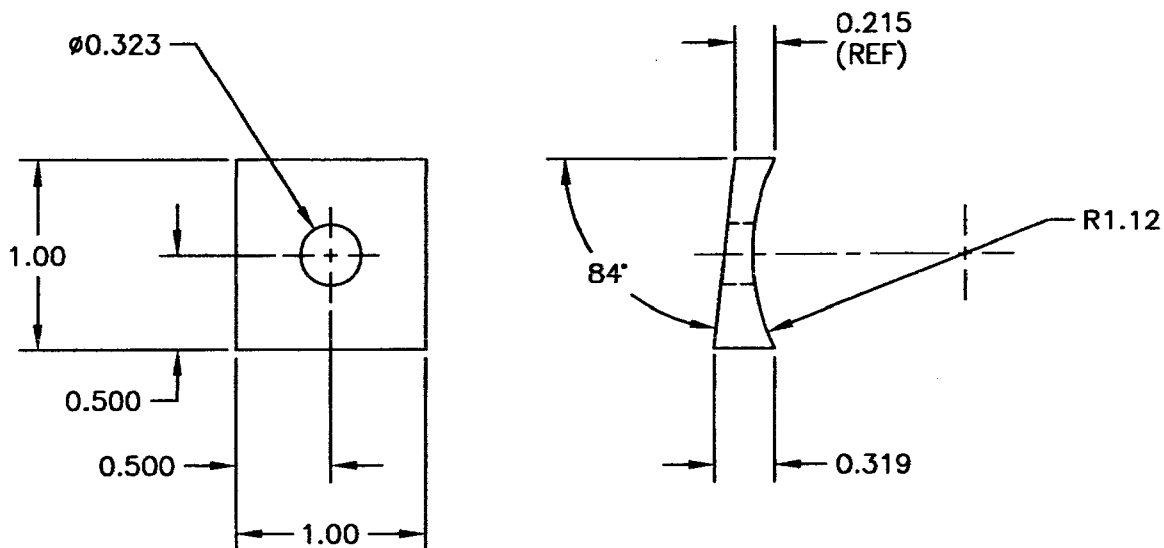
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M.A 09/08/07

**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3520	REV. A SHEET 1 OF 1
DATE 06.06.28		TITLE (A119 BASKET) SPACER	SCALE 1:1
A	06.06.28	NEW ISSUE	

RELEASED

06.11.17 *H***D3520-1 SPACER**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART MATERIAL SPEC M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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